



Dart Aerospace Ltd.
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646.3301

Job Sheet 200586



Part No: 646.3301

Job Qty: 4 pcs

Part Name: Upper Cutter Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 9/12/19

Job Tracking No:

Due Date: 10/4/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG 646.3300 REV.A IPP REV:A 12.10.19 NEW ISSUE DD VERF:JLM IPP REV:B 15.01.07 AS PER DWG
NC3 DD VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Packaging 1 - Pick Kit	4 pcs	10/4/19		0.00	0.00	Packaging 1 - 1		
							Packaging 1 - 2		
							Packaging 1 - 3		
							Packaging 1 - 4		
							Packaging 1 - 5		
							Packaging 1 - 6		
							Packaging 1 - 7		
							Packaging 1 - 8		
							Packaging 1 - 9		
							Packaging 1 - 10		
							Packaging 1 - 11		
							Packaging 1 - 12		
							Packaging 1 - 13		
							Packaging 1 - 14		
							Packaging 1 - 15		
							Packaging 1 - 16		
							Packaging 1 - 17		
							Packaging 1 - 18		
							Packaging 1 - 19		
							Packaging 1 - 20		
							Packaging 1 - 21		
							Packaging 1 - 22		
							Packaging 1 - 23		
							Packaging 1 - 24		
							Packaging 1 - 25		
							Packaging 1 - 26		
							Packaging 1 - 27		
							Packaging 1 - 28		
							Packaging 1 - 29		
							Packaging 1 - 30		

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Container No: S232472



Part: 646.3301

Job No: 200586

Serial No/Batch: S232472

Revision: A

Inspector:

Exp Date:

Instructions: Various STC's

Dart Aerospace Ltd.
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CANADA
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Date: 11/16/19

				Packaging 1 - 31	
				Packaging 1 - 32	
				Packaging 1 - 33	
				Packaging 1 - 34	
				Packaging 1 - 35	
				Packaging 1 - 36	
120 Small Fab - 2 - B4B	4 pcs	10/4/19	0.00 5.56	Small Fab - 1 - B4B	
				Small Fab - 2 - B4B	
				Small Fab - 3 - B4B	
				Small Fab - 4 - B4B	
				Small Fab - 5 - B4B	DAS
				Small Fab - 6 - B4B	41 NOV 16 2019
				Small Fab - 7 - B4B	3-89
				Small Fab - 8 - B4B	
130 QC 5	4 pcs	10/4/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	DEC 10 2019
				QC 5 - 61	
				QC 5 - 81	
140 Packaging 3-1 - Stock - B4B	4 pcs ✓	10/4/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B ✓	CCK018
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
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DEC 10 2019

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DEC 11 2019

Oscar

					Packaging 3 - 27 - B4B	
					Packaging 3 - 28 - B4B	
					Packaging 3 - 29 - B4B	
					Packaging 3 - 30 - B4B	
					Packaging 3 - 31 - B4B	
					Packaging 3 - 32 - B4B	
					Packaging 3 - 33 - B4B	
					Packaging 3 - 34 - B4B	
					Packaging 3 - 35 - B4B	
					Packaging 3 - 36 - B4B	
150 QC 21 - SA	4 pcs ✓	10/4/19	0.00 0.00	QC 21 - SA - 21 ✓	CCK018	
				QC 21 - SA - 70	DAS	
				QC 21 - SA - 53	21	

Part Op 110 - Pick Kit

Descriptions: 120 - Small Fab - TWO fastener must be install finger-tight (see note 9) Assemble as per dwg and apply loctite 598 on all faying surfaces shown on dwg per note 7. ~~exp date~~ 521075 exp 1/21

130 - QC5- Inspect part completeness to step on W/O

140 - Identify as per dwg & Stock Location: ***IDENTIFY AS PER APICAL MPP-120 BY STAMPING THE P# AND REV***

150 - QC21- Final Inspection - Work Order Release

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
646.3310	LH Half - Upper Cutter Assembly	4 pcs (1 ea)	110-Packaging 1 - Pick Kit	5202710
646.3311	RH Half - Upper Cutter Assembly	4 pcs (1 ea)	110-Packaging 1 - Pick Kit	5202297
646.3312	Center Plate	4 pcs (1 ea)	110-Packaging 1 - Pick Kit	5148045
646.3313	Upper Guide	4 pcs (1 ea)	110-Packaging 1 - Pick Kit	5129743 5222200
646.3314	Blade	4 pcs (1 ea)	110-Packaging 1 - Pick Kit	5193366
646.3315	Blade	4 pcs (1 ea)	110-Packaging 1 - Pick Kit	5190730
646.3316	Blade	4 pcs (1 ea)	110-Packaging 1 - Pick Kit	5192284
AN3-12A	Bolt	8 Ea (2 ea)	110-Packaging 1 - Pick Kit	5166926
AN3-14A	Bolt	4 Ea (1 ea)	110-Packaging 1 - Pick Kit	5112900
MS21042L08	Nut	72 Ea (18 ea)	110-Packaging 1 - Pick Kit	5218607
MS21042L3	Nut	12 Ea (3 ea)	110-Packaging 1 - Pick Kit	5218152
MS27039-08-19	Screw	72 Ea (18 ea)	110-Packaging 1 - Pick Kit	5204996
NAS1149F0332P	Washer (AN960-10L)	24 Ea (6 ea)	110-Packaging 1 - Pick Kit	5225418
NAS1149FN832P	Washer (AN960-8)	144 Ea (36 ea)	110-Packaging 1 - Pick Kit	5207676

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
110-Packaging 1 - Pick Kit	646.3310	4	5	0
	646.3311	4	7	0
	646.3312	4	6	0
	646.3313	4	2	0
	646.3314	4	15	0
	646.3315	4	17	0
	646.3316	4	18	0
	AN3-12A	8	146	0
	AN3-14A	4	184	0
	MS21042L08	72	946	0
	MS21042L3	12	1,950	0
	MS27039-08-19	72	885	0
	NAS1149F0332P	24	2,000	0
	NAS1149FN832P	144	2,123	0

Part Specifications

Specifications could not be found.

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date :	Sequence #:	QTY Affected :		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					